

Date: Thursday, 9/14/2006 7:29:06 AM
User: Kim Johnston

Process Sheet

815 04/00/02

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BLOWER INLET ADAPTER
Job Number	: 28560	Part Number	: D3473043
Estimate Number	: 12318	Drawing Number	: D3473 REV.B
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 9/14/2006 S.O. No. : N/A	Drawing Revision	: B
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Due Date	: 10/6/2006
Previous Run	: 26990	Qty:	4 Um: Each
Written By	: <u>06 09 14</u>		
Checked & Approved By	: <u>06 09 14</u>		
Comment	: est rev. A 06.03.02 new issue EC Est Rev:B As per Rev B 06-05-24 JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D34735 VERTICAL TUBE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3473-5	tube	B27019

2.0 D34733 COVER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3473-3	Cover	B27018

3.0 D34739 FLANGE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3473-9	Flange	B26121

4.0 D34731 DUCT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3473-1	Duct	B27017

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Description:

5.0

D34737

HORIZONTAL TUBE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3473-7	Tube	B 27020

6.0

AN960C416L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
2	AN960C416L	washer	M 100 993

7.0

NAS1031C3W

Nutplate



Comment: Qty.: 6.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
6	NAS1031C3W	Nutplate	N/A already installed on u/o 26121

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill hole as per dwg D3473

2-Spot weld as per dwg D3473

FF 06-10-04

MF 06/10/04

9.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 06/10/05

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location GA

SB 06/10/05

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Customer: CU-DAR001 Dart Helicopters Services

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Part Number: D3473043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

SP 06/10/06

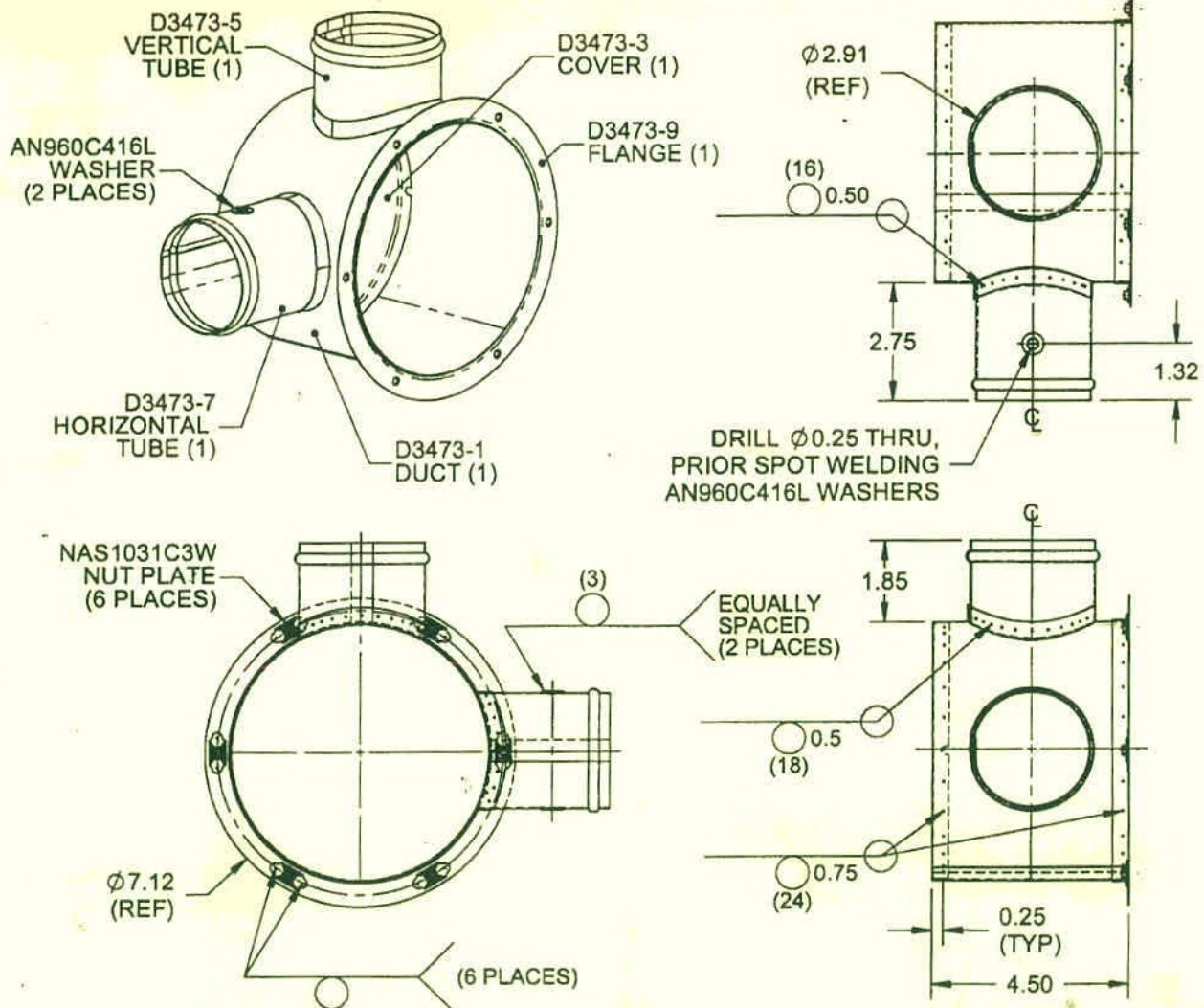
Job Completion



U 06.10.06

DART

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3473	REV. B SHEET 2 OF 7
DATE 06.05.16	TITLE BLOWER INLET ADAPTER		SCALE 1:4

RELEASED
06.05.16 *H***D3473-043 BLOWER INLET WELDMENT****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3473-043	BLOWER INLET WELDMENT
1	D3473-1	DUCT
1	D3473-3	COVER
1	D3473-5	VERTICAL TUBE
1	D3473-7	HORIZONTAL TUBE
1	D3473-9	FLANGE
2	AN960C416L	WASHER
6	NAS1031C3W	NUT PLATE

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NO. 28

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Melanie Fauteux
Joint Welding Procedure Spot Welding
Part number and Job number D3473-043 B28560

TEST WELDS REQUIRED

BASE METAL 304 26G WELDING PROCESS Spot
Penetration Complete ☐ Partial ☐ Single Weld ☐ Double Weld ☐
Current AC ☐ DC ☒ Backing YES ☐ NO ☐ N/A

	Position		Vertical Down <input type="checkbox"/> Up <input type="checkbox"/>	
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

N/A

Crossbolt Spacer Welded into _____ Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐

Crossbolt Spacer Pass ☐ Fail ☐ N/A

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/10/05 Qualifier Sylvie Souder

